Work Order ID : May 25, 2010 1:13:07 PM											Page 1
Item ID: D3542-1			Accept					Setup	Start		
Revision ID: Item Name: Bracket									Stop		
Start Date: 5/25/10 Required Date: 5/31/10	Start Qty: 12.00 Regld Qty: 12.00		((8) (88)	Cust Item I Customer:	D:					1 (1841) 11	1818 118 (18) 1881
Reference:	10.05.25					_			C4a w4		5115 (B) (IB) (B)
Approvals: Process QC:	Plan:	Date:			te:	···			Start Stop		1116 161 1181 1661 . 1116 116 1181 1881 [*]
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejec Qty		Reject Number	Insp. Stamp
Draw Nbr I	Revision Nbr						serv.reg r Scor .com				
D3542	Rev A			• *							
Bandsaw Jeaspa Bandsaw	BAND SAW Memo Cut blank	4.0" long	0.00	10/06/04			·_12	- <i> Q</i>	5		
HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICA Memo 1- Mill as per dwg D	per Folio FA684 Rev: _A	0.00 0.00 • & Dwg D3542 Rev: _	~	5		12	9	,		
120	QC2- Inspect parts off	machine FAI/FAIB		2 10/06/05	-		12	8			
QC	Memo		0.00								

Quality Control

Dart Aeros	space I	Ltd
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W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
·			,									
			·									
						* i						
Part No	:	PAR #:	Fault Categ	jory:	NCR: Ye	es No C	QA:	Date: _				
	R	esolution:	Disposition	:	QA: N/C	Closed:		Date: _				
NCR:		V	VORK ORDE	R NON-CONFORM	ANCE (N	CR)						
DATE	STEP	Description of NC		Corrective Action Section E			ification	n Approval	Approval			
-		Section A	Initial Chief Eng	Action Description Chief Eng:		n & S	ection C	Chief Eng	QC Inspector			
								Ī				
		<u> </u>										

W	ork	Ω	rder	ID	590	151
**	,, ,	\ /	1101		-,,,,,	7.7



Page 2

May 25, 2010 1:13:07 PM

Required Date: 5/31/10

Item ID:

D3542-1

Accept

Setup Start



Revision ID:

Item Name: **Start Date:**

Bracket

5/25/10

QC:

Start Qty: 12.00 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

0.00

0.00

Date:

Date:

Tool # Plan

Code

Start

Run

Stop

Stop



Insp.

Stamp

Reject

Number

Sequence ID/

Work Center ID

130

Quality Control

Operation **Description**

QC8- Inspect parts - second check

Memo

Memo

Memo

Set Up/ **Run Hours**

10/06/06

Tool ID

Accept

Qty

Reject

Qty

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

=7m/ 1406/07



150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

0.00

0.00

Powdercoat

Powder Coating

7 :00 OVEN TEMPERATURE: 2 30 OFINISH
TIME: 320 C

******ENSURE TO MASK INSIDE BORE***** START TIME:

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	PROCEDURE CHANGE					Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
										1		
Part No	:	PAR #:	Fault Cate	egory:	_ NCR	: Yes N	lo DQ	4 :	Date:			
						N/C Closed: Date:						
NCR:		. V	VORK ORD	ER NON-CONFORMA	NCE	(NCR)						
DATE	STEP	Description of NC		Corrective Action Section	on B		Verification Approval			Approval		
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector			
<u></u>												
		·				·						
	1	1			1		1			i ·		

Work Order ID 59051

May 25, 2010 1:13:08 PM

Page 3

Item ID:

D3542-1

Revision ID: Item Name: Bracket

Start Date:

5/25/10

QC:

Start Qty: 12.00 Req'd Oty: 12.00

Accept

Setup Start

Stop



Required Date: 5/31/10

Reference:

Approvals:

Process Plan:

Date:

Tooling: Date:

SPC (Y/N):

Date: _____ Date:

Run

Start

Stop

Sequence ID/ **Work Center ID**

160

Quality Control

Operation Description

QC3- Inspect Part Finish

Memo

Set Up/ **Run Hours**

0.00

0.00

Tool ID

Cust Item ID:

Customer:

Tool # Plan Code Accept **Qty**

Reject Qty

Reject Insp. Number Stamp

170

Packaging Packaging

Identify as per dwg & Stock Location: 273

Memo

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/14 98f

Dart Aerospace	L	_tc	1
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-											
W/O:		WORK ORDER CHANGES									
STEP		PROCEDURE CHANGE					te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		PAR #:	Fault Ca	tegory:	_ NCR: Ye	s No	DQA:	Date: _			
Resolution:											
			WORK OR	DER NON-CONFORM	ANCE (NO	R)			-		
STEP	Description of NC					v	erification	Approval	Approval		
0.2.		Section A	Initial Chief Eng	Action Description Chief Eng			Section C	Chief Eng	QC Inspector		
		•									
								10-9,07			
		Resolut	:PAR #: Resolution: STEP Description of NC Section A	STEP PAR #: Fault Ca Resolution: Disposit WORK OR STEP Description of NC Section A Initial Chief Eng	STEP PAR #: Fault Category:	STEP PAR #: Fault Category: NCR: Ye Resolution: Disposition: QA: N/C WORK ORDER NON-CONFORMANCE (NC STEP Description of NC Section A Initial Action Description Chief Eng Chief	STEP PAR #: Fault Category: NCR: Yes No Resolution: Disposition: QA: N/C Closed WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PAR #: Fault Category: NCR: Yes No DQA: Besolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC	STEP PROCEDURE CHANGE By Date Qty Approval Chief Eng / Prod Mgr. PAR #: Fault Category: NCR: Yes No DQA: Date: Date: Disposition: QA: N/C Closed: Date: Date: Step Part of NC Section A Action Section B Section B Section A Chief Eng Chie		

Picklist Print

May 25, 2010 1:13:07 PM

Work Order ID: 59051

D3542-1

Parent Item Name:

Component Item ID/

M6061T6B30000X01.5

Bracket

Comments:

Item Name

Parent Item:

IPP Rev: A New Issue

Item ID

IPP Rev: B updated powder coat per NCR 07.05.16

Purch

Purchased

Replacement Mfg/

Bin

Primary Item Location

No

Last Location

JLM

EC

Route Seq ID 100

Unit of

Qty on Measure Hand 29.1526

0.3333333

Start Qty: 12.00

Otv

4

Qty

Issued

Date Status Issued

Page

00

6061-T6 Bar 3.00 x 1.50

Location

MAT

109058 114468 Loc Qty

29.1526 11.4926 17.66 Loc Code

4.000 AF 10/06/24

07-04-23

Start Date: 5/25/10

Qty per Kit Total

Required Date: 5/31/10

Required Qty: 12.00

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA :	Date: _				
					QA: N/C Closed: Date:						
NCR:		\	NORK OR	DER NON-CONFORM	ANCE (NCR)					
DATE	STEP Description of NC		Initial		tion B	Verification	1 Approval	Approval			
		Section A	Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
							,				
		,									
	,]										

DART AEROSPACE LTD	Work Order:	5905/
Description: Bracket	Part Number:	D3542-1
Inspection Dwg: D3542 Rev: A		Page 1 of 1

	FIRST ARTICLE INSPECTION CHECKLIST									
		X First Ar	_	_	totype					
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Co	omments			
Ø2.010	+0.005/-0.000	\$2.012								
Ø2.50	+0.012/-0.001	Ø2.570/	/							
3.75	+/-0.030	3.752	/							
2.50	+/-0.010	2.500	/							
1.00	+/-0.010	1.000	_							
0.06 x 45°	+/-0.030 x 0.5°	.065×45°								
Ø0.266	+0.006/-0.001	0.268								
1.00	+/-0.030	996 .996								
0.50	+/-0.030	991								
0.500	+/-0.010	. 5700								
							, 			
					•					
Measured by:		Audited by:	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \] [Prototype App	rovoli	N/A			
Date:	10/06/05	Date:	 'V' 	0/06		Date:	N/A			

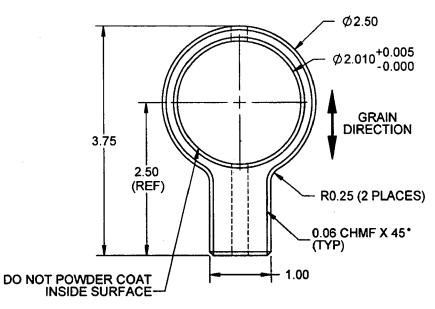
Rev	Date	Change	Revised by	Approved
Α	07.06.13	New Issue	KJ/JLM 🛠	E

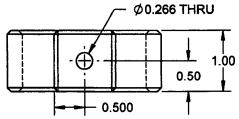


	DESIGN			DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	CHECK	ŒD		APPROVED	DRAWING NO.	REV. A
		k	3	-4	D3542	SHEET 1 OF 1
	06.11.27				TITLE	SCALE
				1.27	BRACKET	2:3
_	REV	DATE		DATE	DESCRIPTION	
	Α			06.11.27	NEW ISSUE	

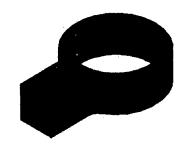


w/o 5905/





D3542-1 BRACKET



1) MATERIAL: 6061-T6 ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6B)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3 EXCEPT WHERE NOTED 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3542-1" USING FINE POINT PERMANENT INK MARKER 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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